

Work Order ID 142808

March 11, 2016 2:36:02 PM

U/R

142808

Special Sign off required
by engineering
Ship March 30-

Page 1

Item ID: D412-775-013

Accept

N900040100

Setup Start

NS1

Revision ID: URF 16-532

Item Name: Step Protective Trim

Stop

NS2

Start Date: 3/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/30/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: SH

Date: 20160311

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
DSI 9503	A								
IIN D412-775	Rev A U/R								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-775-013 CHG003								

105 Pick Kit 0.00

105

Packaging

Memo

0.00

Packaging

MAR 29 2016

MAR 31 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 142808***142808***

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Item ID: D412-775-013

Accept

N900040100Setup Start ***NS1***

Revision ID: URF 16-532

Item Name: Step Protective Trim

Stop ***NS2***

Start Date: 3/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/30/2016 Req'd Qty: 1.00

1

Customer:

Reference:

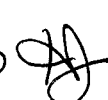
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC4- 100% Inspect kits for completeness	0.00							
110							DAS 28		
QC	Memo	0.00					9-23		MAR 31 2016
Quality Control									
120	Packaging	0.00							
120							DAS 28		
Packaging	Memo	0.00					9-23		MAR 31 2016
Packaging	Identify and pack for shipping as per PPP D412-775-013 Location: FG028								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

16/5/10 mf
16-5-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Picklist Print

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Work Order ID: 142808

142808

Parent Item: D412-775-013

D412-775-013

Parent Item Name: Step Protective Trim

Start Date: 3/23/2016

Required Date: 3/30/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-10 new issue DD verified by:ec
kit DD 10.02.18 Verified By:EC IPP Rev:B add pick

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3608-1		Manufactured	No			110	Each	19.0000	1	1			
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D3608-1

Lower Doubler

DAS
28
9-89

Location

Loc Qty

Loc Code

ST222

19

19

110

Each

20.0000

1

1

142808

WF

DAS
8
9-89

D3608-3

Manufactured

No

D3608-3

Upper Doubler

Location

Loc Qty

Loc Code

ST222

20

20

141120

DAS
28
9-89

MAR 29 2016

DAS
8
9-89

Under Review Notification

Raised By: M. BELLAVANCE

Product #: D412-775-013

Date: 16.02.25

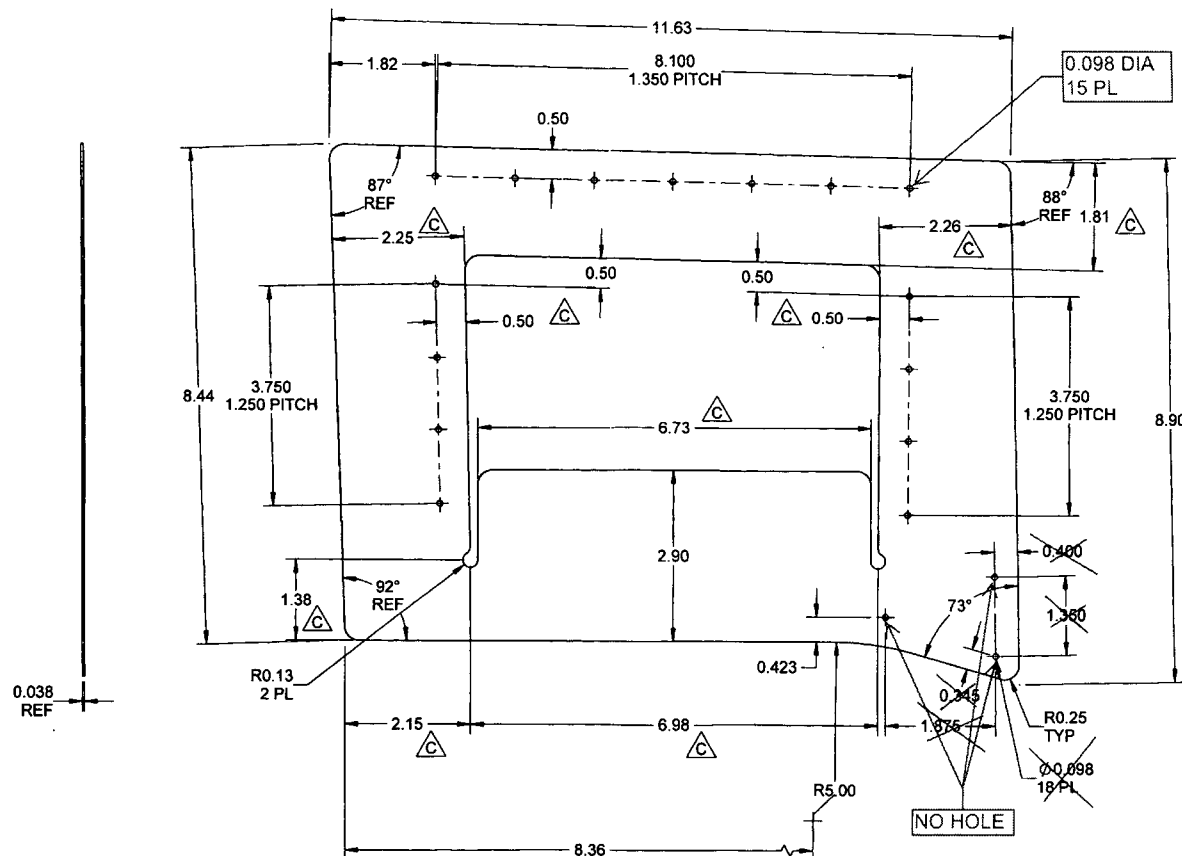
Product Name: STEP PROTECTIVE TRIM KIT

Part Number (D-Part and 9-Digit)	Drawing/Document & Current Affected Revision	"Y" or "N" Required for Each Part							Reserved ECN Log Number	Instructions Relevant to Each Part
		HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise Customers	Stop Production	Re-Work Stock	IPP Under Review	Product Specifications Under Review		
D3608-1	D3608 Rev. C	N	Y	N	Y	N	Y	N	TBD	See below.
D412-775-013	IIN-D412-775 Rev. A	N	Y	N	Y	N	Y	N	16-532	See below.

Description of Issue:

Current stock OK to ship to customers other than Bell Helicopter Mirabel.

If shipping to Bell Helicopter Mirabel: must ship D412-775-013 with D3608-1 minus 3 holes as per attached. Eng. to sign off deviations on W/Os.



RELEASED
2010-11-23

D3608-1 LOWER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.76 lbs

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE	MB	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F/3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER FAR809-097	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3608 TITLE DOUBLER SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	13		
CHECKED	13		
MFG. APPR.	13		
APPROVED	13		
DE APPR.	13		
DATE	10.11.19		

20150377
SH 142808

